

# Work Order ID 52515

September 29, 2009 10:47:48 AM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: GHW Lug

Start Date: 29/09/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*RF*

Date:

*09-9-29*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3404

Rev C

100

0.00



BAND SAW

*H.A 09/10/02*

*20*

*φ*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.750" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

*H.A 09/10/06*

*20*

*φ*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 □ Dwg Rev: *C* Folio Rev:  
*AA* □ 2-Deburr

120

0.00



QC2- Inspect parts off machine FAI/FAIB

*H.A 09/10/06*

*20*

*φ*

QC

Memo

0.00

Quality Control

**Work Order ID 52515**

Page 2

September 29, 2009 10:47:48 AM

Item ID: D3404-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: GHW Lug

Start Date: 29/09/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mf  
09/10/07

20

X

140

Identify as per dwg & Stock Location: EL

0.00



Packaging

Memo

0.00

Packaging

9/10/1

20X 5/1

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/08

mf  
09-10-08

# Picklist Print

Page 1

September 29, 2009 10:47:48 AM

Work Order ID: 52515



Parent Item: D3404-1RevC



Parent Item Name: GHW Lug

Start Date: 29/09/2009

Required Date: 06/10/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	50.3000	4.8232			
304 BAR .750 X 2.50												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

MAT

50.3

112663

14

112697

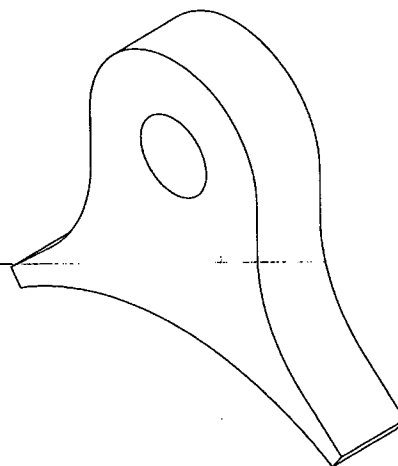
36.3

4.600Y.A  
09/10/02



SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 52515

*PH* 09-9-29



**D3404-1 GHW LUG**

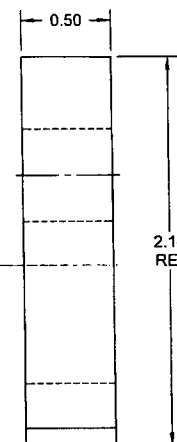
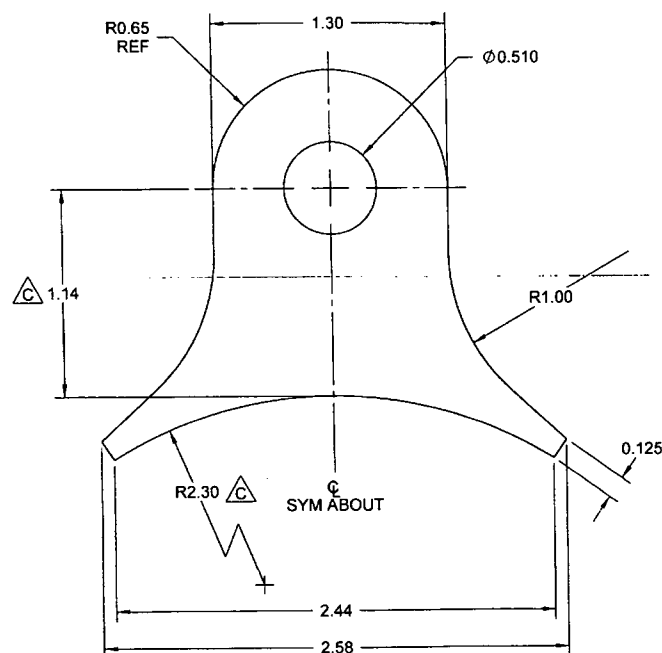
**RELEASED**  
*08/12/13 NW*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR  
 PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
 REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3404	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHOP  
RETURN  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO APPROVAL  
WITHOUT  
WORK ORDER  
NO. 52515  
*BS*



**RELEASED**  
08/12/18 *WJ*

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3404	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GHW LUG	NTS
DATE	08.12.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	